Imron® AF400™
Polyurethane Topcoat (EP Quality)

GENERAL

DESCRIPTION
A 3.5 VOC compliant, high solid, polyurethane topcoat designed to deliver high performance, excellent appearance and durability on both propeller and rotary aircraft. It is available in factory-packaged whites and various mixed colors.

RECOMMENDED USES
Imron® AF400™ is recommended for riveted aircraft and similar general aviation applications where excellent appearance, durability, sag resistance, and ease of use are required. Imron® AF400™ is ideal for air dry applications where forced drying (bake) is not available and offers activator options for optimum performance in both accent stripe and overall body color applications. Imron® AF400™ is recommended for use with the following other products:

Primer	Corlar® 13550S™, Corlar® 13580S™
Basecoat	Imron® AF700™
Clearcoat	Imron® AF740™

MIXING

COMPONENTS
Imron® AF400™ Color (EP Quality)
Imron® AF403™ Snow White Factory Package
Imron® AF404™ Matterhorn White Factory Package
13100S™ Activator (For Effect Colors, Stripes, and Repairs)
13110S™ Activator (For Overall Body Solid Colors)

MIX RATIO
Thoroughly mix Imron AF400 color prior to activation. Filter activated material prior to application.

Component	Parts by Volume
Imron® AF400™ Color (EP Quality)	3
13100S™ / 13110S™ Activator	1

13100S™ is recommended for small parts and repairs.

VISCOSITY
11-16 seconds in a Zahn #3 Cup.
Listed ranges were established using GARDCO EZ Zahn (ASTM) Cup. A measurement using other Zahn type cups may provide a different result.

INDUCTION TIME
No induction time is required prior to application.

POT LIFE
2 hours at 70°F (21°C) with 13801S™ or 13803S™
45 minutes at 75°F (24°C) with 13808S™

ADDITIVES (OPTIONAL)
Accelerator
- Add up to 2 oz. 13801S™ per RTS gallon to improve pot life/dry time
- Add up to 2 oz. 13803S™ per RTS gallon to improve dry time

- Add up to 1 oz. 13808S™ per RTS gallon for fast dry; limited area work

Anti-crater (solid color only)
- Add up to 1 oz. 13813S™ per RTS gallon

For Reduced Gloss
- Use PT196™ Flattener

Adding 2 oz. 13801S™ or 13803S™ per RTS gallon is recommended for most all applications to provide longer pot life.

APPLICATION

SUBSTRATES AND SURFACE PREPARATION
Surface preparation is critical to topcoat appearance. Primer should be properly applied and cured according to product recommendations. Surfaced substrate should be DA sanded with 280-grit or finer for best appearance. Substrate should always be thoroughly wiped/tacked immediately prior to topcoat application.

ENVIRONMENTAL CONDITIONS
Substrate and ambient temperature must be between 50°F (10°C) and 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%. Heating activated material above 110°F (43°C) may cause gelation. For optimum appearance spray Imron AF400 at 75°F (24°C) or warmer.

GUN SETUP
Imron® AF400™ can be applied with conventional, HVLP, Air-Assisted Airless, and Electrostatic Spray equipment using pressure or gravity fluid delivery.

Conventional Fluid Tip

Pressure Pot	1.0mm-1.4mm (.039”-.055”)
Gravity Feed	1.2 mm-1.6 mm (.047”-.063”)

HVLP

Pressure Pot	1.0 mm-1.4 mm (.039”-.055”)
Gravity Feed	1.2 mm-1.6 mm (.047”-.063”)

FLUID DELIVERY

Conventional	8-10 oz./minute
HVLP	8-10 oz./minute

AIR PRESSURE

Conventional	50-60 psi atomizing air
HVLP	25-30 psi atomizing air

APPLICATION
- Spray a medium wet first coat followed by a second medium wet second coat after a 30 second to 5-minute flash time to achieve 2.0-2.5 mils dry film build.
- Effect colors should be applied using 13100S™ activator utilizing the same technique as above with the option of a control coat applied 10-12 inches from substrate immediately following the second medium wet coat to minimize mottling or tiger stripping.

CLEANUP SOLVENTS
Axalta 107™ Low VOC Gun & Equipment Cleaner
Axalta 105™ Gun & Equipment Cleaner

DRY TIMES

AIR DRY

At 70°F (21°C) with 2 oz. 13803S™ per ready-to-spray gallon

Dry to Touch	2-3 hours
Dry to Tape	4-7 hours

FORCE DRY

30-minute by 130°F (54°C) with 2 oz. 13803S™ per ready-to-spray gallon

Flash Before Force Dry	15 minutes
Dry to Touch	1-2 hours
Dry to Tape	3-4 hours

RECOAT

When recoating Imron® AF400™ with itself or Imron® AF700™ basecoat, scuff sanding is required if the topcoat has air dried for more than 48 hours or 24 hours if the topcoat has been force dried or accelerated with 13808S™.

PHYSICAL PROPERTIES

VOC INFO

	Less Exempts (LE)	As Packaged (AP)
Imron® AF400™ Color	3.8 lbs./gal	3.6 lbs./gal
Ready-To-Spray	3.4 lbs./gal	3.2 lbs./gal

FACTORY-PACKAGED AND MIXED COLORS

Color (EP quality custom color mixes)	Solid and Metallic
Closed Cup Flash Point	20°F-73°F
Shelf Life (stored at 50°-110°F)	Factory Package - 2 years (Unopened) Mixed Color – 1 year Reduced Gloss – 6 months

READY-TO-SPRAY*

Theoretical Coverage	850 ft^2/gal AVG at 1 mil dry film thickness (820-870 ft^2/gal)
Weight Solids	63% AVG (57-68%)
Volume Solids	53% AVG (49-52%)
Gallon Weight	9.2 lbs./gal AVG (8.3-10.8 lbs./gal)

DRY FILM

Gloss	≥90 measured at 60°
Optional Reduced Gloss*	0-10 Flat, 25-45 Satin at 60º angle
Recommended Film Thickness	2.0-2.5 mils

*Contact your Axalta representative for availability.

COATING PERFORMANCE

Chemical and Solvent Resistance	Excellent
Weathering	Excellent
Humidity Resistance	Excellent
Acid and Alkali Resistance	Excellent
Abrasion Resistance	Excellent
Flexibility	Excellent

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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